

**Aero Design Ltd.****Work Order Control Sheet**Work Order#: 2017-82Date Opened: 04 May 2017Title: AssemblyAircraft OEM: BellAircraft Model: 206L/407Product Type: Cargo BasketProduct Model: Standard Quantity: 1**Work Order Contents**

Work Order/Build Sheets (Procedures Provided)  
 Additional Work Sheets (Standard Practice)  
 Drawings (See List Below)  
 Parts Distribution Sheet  
 Sub Component Tags  
 Completed Certification (Original)  
 Time Sheet (R&D)  
 Notes

Initial or N/A

KB
N/A
KB
KB
KB
JC
N/A
N/A

**Build Sheet Contents**

Tasks Initialled  
 Dual Inspections Initialled

Initial or N/A

JC
JC

**Drawing List**

Drawing #	Rev #	Description	Initial or N/A
69810	3	Basket	KB
69827	2	Placard	KB
70405	4	Walkway	KB
84255	2	Handle Installation	KB
84240	0	Lid Prop Installation	KB

**Traveller**

Install walkway on lid  
 Install lid on basket body  
 Re-tap mounting lug holes and install mount lugs  
 Install handle brackets  
 Install handle  
 Install lid prop  
 Install data plate

Initial or N/A

KB
KB
KB
KB
KB
KB
KB

Work performed by:

Print: K. BevansSign: K. Bevans

ICC / Dual Inspection performed by:

Print: J. RekveSign: J. Rekve

Work Order closed by:

Print: J. ClarkeSign: J. Clarke

Approved Manufacturing Facility 73-04

Form 2010.03

**Component Completion**

Quantity Complete on This Work Order  
 Quantity Incomplete on This Work Order  
 Further Processing Required Before Release  
 Release to Stock as Components

As Instructed

1
N/A
N/A
N/A

**Certification**

Form One Completed  
 Serviceable (Green) Tag Completed  
 In Process (Yellow) Tag Completed  
 Unserviceable (Red) Tag Completed  
 Parts Placed in Stores for Distribution

Initial or N/A

JC
N/A
N/A
N/A
N/A

**Additional Documentation**

Documentation of a minor change  
 Non-Conformance Report Required  
 Service Difficulty Report Required

Initial or N/A

N/A
N/A
N/A

**Billing**

Local (Aero Design)  
 Research and Development  
 Third Party

Initial or N/A

JC
N/A
N/A

SCA: JC-Supervised  
 SCA: AD01  
 SCA: AD02

Date: 05-May-17Date: 05-May-17Date: 05-May-17

Rev. Original 23 Sep 2014



## **Aero Design Ltd.**

9888 A Malaspina Rd., Powell River, BC  
V8A 0G3, 604-483-AERO (2376)

Quantity: 1

PN: MS20001P4-9600

Aircraft: Multiple                      Model: Multiple

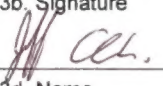
Description: Hinge

Supplier: Bisco

Color: N/A

WO#: N/A

PO# 16030

1. Approving Civil Aviation Authority/Country <b>Transport Canada</b>		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No. <b>2017-0175</b>
4. Organization Name and Address <b>AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3</b>					5. Work Order/Contract/Invoice <b>WO 2017-82</b>
6. Item <b>1.</b>	7. Description <b>Cargo Basket</b>	8. Part Number <b>69810-01</b>	9. Qty. <b>1</b>	10. Serial/Batch No. <b>69801-88</b>	11. Status/Work <b>New</b>
12. Remarks <b>Modified with walkway on lid and front end cutout IAW DCL704</b>					
13a. Certifies that the items identified above were manufactured in conformity to:  <input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			<del>14a. <input type="checkbox"/> CAR 571.10 Maintenance Release  <input type="checkbox"/> Other regulation specified in block 12          Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.</del>		
13b. Signature  <b>AD 73-04 02</b>		13c. Approved Organization Number <b>AMF 73-04</b>		<del>14b. Signature 14c. Approved Organization Number</del>	
13d. Name <b>Jeff Clarke - AD02</b>		13e. Date (dd/mmm/yyyy) <b>05 May 2017</b>		<del>14d. Name 14e. Date (dd/mmm/yyyy)</del>	
<b>Installer Responsibilities</b> This certificate does not constitute authority to install. Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified. Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.					

MINUTEMAN AVIATION



## Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: Medium Handle No. of pieces: 1

Manufacturer: Aero Design Ltd.

Part No.: 84261 Rev1 Serial/Batch No.: NA

TTSN: NA TSO: NA Rem.: NA

Work Order No.: 2017-31

Remaining Tasks to be Performed: clean up, inspect, tag,  
stock.

Signature: Ravi D. Murti

Date: May 1/2017 Lic. No. / SCA AD-05

In Process



## Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: [info@aerodesign.ca](mailto:info@aerodesign.ca)

AMF 73-04

**In Process**

**Remarks**

Completed 05 MAY 2017 JC.



## **CARGO BASKET ASSEMBLY - COMMON**

### **General**

These instructions apply to all cargo basket assemblies. Refer to the following drawings, at the current revision, for dimensions and details:

#### **Bell 206L/407 – Right side only**

69810, Revision 3 – Standard Low Mounted Basket

94510, Revision 0 – Extra-Wide Low Mounted Basket

94610, Revision 0 – Extra-Wide Low Mounted Ski Basket

76610, Revision 0 – High Mounted Ski Basket

#### **Eurocopter AS350/AS355 – left or right**

77610, Revision 1 – Short Basket

76410, Revision 3 – Medium Basket (left or right)

78410, Revision 2 – Long Basket

94010, Revision 0 – Extra Large (ski) Basket

#### **Robinson R44 – left or right**

90610, Revision 0 – Standard Basket (left or right)

#### **Bell 206B – right side only**

80210, Revision 0 – Short Basket

80310, Revision 0 – Medium Basket

81110, Revision 0 – Long Basket

#### **Bell 429 – right or left**

95911, Revision 0 – Standard Basket

#### **Bell Medium – left or right**

75111, Revision 0 – Standard Basket

95511, Revision 0 – Extra Large (ski) Basket

#### **MD600**

82811, Revision 0 – Standard Basket

#### **Options**

70405, Revision 3? – Lid Walkway

## CARGO BASKET ASSEMBLY - COMMON

Complete  
(initial or SCA #)

Work Order: 2017-82

Date Open: 25 Feb 04 May 2017

AD  
73-04  
02 KB

### 1. Lid Assembly

- a. Install lid bumpers on bottom.
  - i. Fill bumper holes with RTV silicone sealant.
  - ii. Insert 49205-14 lid bumper, 3 or 4 places per lid.
- b. Install placard on bracket on top of lid.
  - i. Locate placard on bracket.
  - ii. Drill #30 through placard and bracket, using holes in placard.
  - iii. Remove placard and de-burr holes in placard and on bracket.
  - iv. Locate placard on bracket, and cleco in place.
  - v. Rivet placard with four CR3213-4-02 CherryMax rivets.
- c. Option: Install walkway on top of lid (lid must be fitted with walkway provisions)
  - i. Note: avoid touching surface of tread plate with bare hands to prevent smudges or marks on the top surface.
  - ii. Pull tread plate from stock. Shear tread plate to length.
  - iii. De-burr edges of tread plate with scotch-brite disc on die-grinder.
  - iv. Locate tread plate on lid. Hold tread plate in place with bags of lead shot.
  - v. Mark and drill #30 holes:
    1. 0.25" from edge of tread plate, centre on cross members (0.38")
    2. 0.25" from edge of tread plate, middle of each walkway stringer
  - vi. De-burr and counter-bore (if required to provide clearance of rivet head on checker pattern) all holes in tread plate using 1/4" piloted counter bore on both sides.
  - vii. De-burr holes in lid tubes.
  - viii. Apply bead of RTV silicone sealant along all tubes under tread plate.
  - ix. Set tread plate in place, secure with clecos if necessary.
  - x. Rivet ~~placard~~ <sup>walkway</sup> with CR3213-4-02 CherryMax rivets
- d. Record PO/WO of all parts (including lid) used in steps above on attached material tracking list.

AD  
73-04 KB  
02

### 2. Body Assembly

- a. Install attachment fittings
  - i. Carefully remove excess powder coat from around attachment lug threads using a countersink.
  - ii. Run 3/8-24 tap into attachment lugs to clear threads.
  - iii. Apply anti-seize compound to attachment fittings 96710-01 (alternate: Ancra 40088-14)
  - iv. Install attachment fittings with two NAS1149F0363P washers in four lugs in basket.
    1. 90610 (Robinson R44) basket only:
      - a. Install 1 fitting 906?? in lower forward attachment lug only.
      - b. Install 3 96710-01 fittings in remaining locations.
- v. Torque to ??



## CARGO BASKET ASSEMBLY - COMMON

Complete  
(initial or SCA #)

- b. 946 Basket Only: Install Cutout Brace – *must be completed after hinge installation*
  - i. Locate 94621-01 Brace over aft cross tube cutout
  - ii. Install two AN4-6A bolts and two AN4-30A bolts with NAS1149F0463P washers.
  - iii. Torque AN4 bolts to ??
- c. Record PO/WO of all parts (including basket) used in steps above on attached material tracking list.

AD  
73-04  
02 kb

### 3. Hinge Installation

- a. Prepare hinge.
  - i. Cut hinge to length:
    - 1. 776, 906 – 54"
    - 2. 751, 803 – 70"
    - 3. 698, 764, 945 – 72"
    - 4. 784 – 90"
    - 5. 940, 946, 959 – 95"
  - ii. Drill #30 pilot holes using hinge jig. For long hinges, flip at specified location on jig.
- b. Install hinge on basket
  - i. Locate hinge on basket (standard baskets)
    - 1. centre fore/aft
    - 2. 0.15" – 0.18" up from bottom edge
  - ii. Locate hinge on basket (extra wide baskets)
    - 1. centre fore/aft
    - 2. set hinge at 90 degrees (as if lid would be installed) using a small square, locate vertical side at 22.5" from outboard edge.
  - iii. Drill #30 through holes in hinge into basket rim. Cleco in place with 1/8 (copper) clecos.
  - iv. Drill holes up to #21 through hinge and rim. Replace 1/8 clecos with 5/32 (black) clecos.
  - v. Remove hinge and de-burr holes in hinge and basket rim.
  - vi. Cleco hinge to basket with 5/32 clecos.
  - vii. Install hinge with CherryMax rivets
    - 1. CR3523-5-02 monel rivets – last 2 rivets in each end
    - 2. CR3213-5-02 aluminum rivets – all other locations
- c. Install lid on basket
  - i. Locate lid on hinge (all baskets)
    - 1. center fore/aft
    - 2. 0.15" – 0.18" down from top edge
  - ii. Drill #30 through holes in hinge into lid rim. Cleco in place with 1/8 clecos.
  - iii. Drill holes up to #21 through hinge and rim. Replace 1/8 clecos with 5/32 clecos.
  - iv. Remove hinge and de-burr holes in hinge and lid rim.
  - v. Cleco lid to hinge with 5/32 clecos.
  - vi. Install hinge with CherryMax rivets
    - 1. CR3523-5-02 monel rivets – last 2 rivets in each end
    - 2. CR3213-5-02 aluminum rivets – all other locations



## CARGO BASKET ASSEMBLY - COMMON

Complete  
(initial or SCA #)

AD  
73-04  
02 KB

- d. Record PO of hinge and rivets on attached material tracking list.

### 4. Install Handle

#### a. Install handle brackets.

- i. Set 84267-01 handle bracket on provisions in hoops, 2 places.
- ii. Install AN3-11A bolt, NAS1149F0363P washer (2), MS21044N3 nut. Two places per bracket, two brackets per basket.
- iii. Torque AN3 bolts to ??.

#### b. Install handle

- i. Trim 36278-01R and 36278-01L springs to ensure end of spring does not extend past edge of handle bracket, approximately 1/8". Set springs over bushing of 84261-01 handle assembly.
- ii. Grease two 36275-01 bushings with ???. Insert into bushings of handle assembly.
- iii. Locate handle on basket lid. Insert AN3-12A bolt with NAS1149F0363P through bracket on lid and handle bushing on one end of handle.
- iv. On other end of handle, hook spring over catch rivet on handle assembly and use spring tool to twist spring to catch arm on bracket on lid while inserting AN3-12A bolt with NAS1149F0363P washer through lid bracket and handle bushing.
- v. At first end, remove bolt and repeat step iv.
- vi. Install NAS1149F0363P washer and MS21044N3 nut on both AN3-12A bolts.
- vii. Torque AN3 bolts to ??.

#### c. Check handle

- i. Operate handle to ensure handle does not bind and springs hold handle in.
- ii. Snap handle into brackets to ensure handle locks.

- d. Record PO/WO of all parts used in steps above on attached material tracking list.

AD  
73-04  
02 KB

### 5. Install lid brace

- a. Locate 36280-01 lid brace on bushing in basket. Ensure brace is on forward end of basket as it will be installed on the helicopter.
- b. On lid end, insert AN970-3 washer into end of lid brace. Insert AN3-15A bolt with NAS1149F0363P washer through AN970-3 washer, lid prop, and lid bushing. Install NAS1149F0363P washer and MS21044N3 nut on bolt.
- c. On basket end, insert AN3-17A bolt with AN970-3 washer through lid prop and basket bushing. Install NAS1149F0363P washer and MS2144N3 nut on bolt.
- d. Ensure brace is seated on lip of bushings before tightening nuts.
- e. Torque AN3 bolts to ??
- f. Record PO/WO of all parts used in steps above on attached material tracking list.

## CARGO BASKET ASSEMBLY - COMMON

Complete  
(initial or SCA #)

AD  
73-04  
01

### 6. Final Inspection

Dual inspection by a different person than assembled the basket.

#### a. Check for general condition and correct assembly:

- i. Bolts are tight
- ii. Rivets are installed correctly
- iii. Handle operates correctly
- iv. Lid brace operates correctly

#### b. Check that PO/WO numbers have been recorded.

Work Order: 2017-82

Material Tracking Sheet  
 Bell 206L / 407  
 Standard Basket Assembly

1 of 2

Date Opened: 04 MAY 2017

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
	1		69810-01	<b>Cargo Basket Assembly</b>	<i>SN 69801-88</i>	
<b>Step 1</b>				<i>Lid Assembly</i>		
Step 1.a.	. 1		69812-01	Basket Lid Assembly		<i>2017-49</i>
	.. 3		49205-14	Bumper	Argus Industries Bumper	
	.. A/R		--	Sealant	Commercial Silicone RTV sealant	
Step 1.b.	.. 1		69827-01	Placard	0.063 Sheet, 6061-T6 Aluminum	<i>2015-03</i>
	.. 4		CR3213-4-02	Cherry Rivet		<i>16053</i>
Step 1.c. (option)	. 1		70405-01	Lid Step Modification		
	.. 1		70405-04	Tread Plate	3003 Aluminum Tread Plate, 0.063"	<i>17011</i>
	.. A/R		CR3213-4-02	Cherry Rivet		<i>16053</i>
	.. A/R		--	Sealant	Commercial Silicone RTV sealant	
<b>Step 2</b>				<i>Basket Assembly</i>		
Step 2.a.	. 1		69811-01	Basket Body Assembly		<i>2016-93</i>
	.. 4		96710-01	Fitting	Alternate: Ancra 40088-14	
	.. 8		NAS1149F0663P	Washer		
<b>Step 3</b>				<i>Hinge Installation</i>		
	. 1		MS20001P4	Piano Hinge	72"	<i>16030</i>
	. 8		CR3523-5-02	Cherry Rivet		<i>16053</i>
	. A/R		CR3213-5-02	Cherry Rivet		<i>16053</i>
<b>Step 4</b>	. 1	84255	84255-01	<i>Handle Installation</i>		
Step 4.a.	.. 2		84267-01	Bracket	Delrin, 3/4" Sheet	<i>2017-50</i>
	.. 4		AN3-11A	Bolt		
	.. 8		NAS1149F0363P	Washer		
	.. 4		MS21044N3	Nut		



Work Order: 2017-82Material Tracking Sheet  
Bell 206L / 407  
Standard Basket Assembly

2 of 2

Date Opened: 04 MAY 2017

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
Step 4.b.	1		84261-01	Handle Assembly		2017-31
	2		36278-01	Spring (1 left, 1 right)	304 Stainless, 1/16" Dia Music Wire	
	2		36275-01	Bushing	Brass, 5/16" Dia	
	2		AN3-12A	Bolt		
	4		NAS1149F0363P	Washer		
	2		MS21044N3	Nut		
Step 5				Lid Brace Installation		
	1		36280-01	Brace Assembly		2017-38
	1		AN3-15A	Bolt		
	1		AN3-17A	Bolt		
	2		AN970-3	Washer		
	3		NAS1149F0363P	Washer		
	2		MS21044N3	Nut		
Step 6				Inspection	None	



## Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: BASKET BODY (206L/407 Std) No. of pieces: 1

Manufacturer: AERO DESIGN LTD

Part No.: 64511-01 Serial No.: NSN

TTSN: N/A TSO: N/A Rem.: N/A

Work Order No.: 2016-93

Remaining Tasks to be Performed: NONE

Signature: Jff Cich.

Date: 03 APR 2017 Lic. No. / SCA AD02

Serviceable



## Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: [info@aerodesign.ca](mailto:info@aerodesign.ca)

AMF 73-04

### Remarks

Serviceable

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## Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: LD (MED) No. of pieces: 1

Manufacturer: AERO DESIGN LTD.

Part No.: 69812-01 Serial/Batch No.: NSJ

TTSN: N/A TSO: N/A Rem.: N/A

Work Order No.: 2017-49

Remaining Tasks to be Performed: ASSEMBLY w/ BODY

Signature: Jff Ceh.

Date: 04 MAY 2017 Lic. No. / SCA AD02

Serviceable



## **Aero Design Ltd.**

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: [info@aerodesign.ca](mailto:info@aerodesign.ca)

**AMF 73-04**

**Serviceable**

**Remarks**

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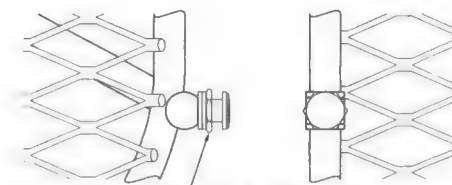
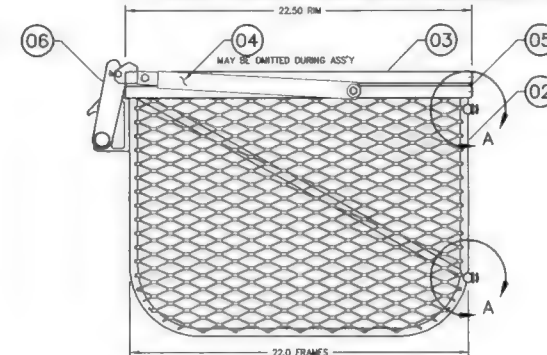
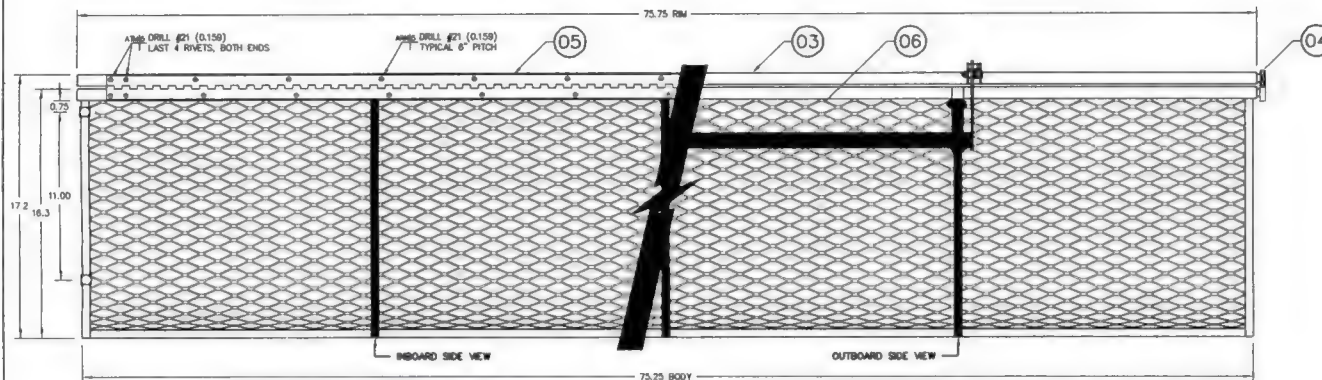
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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
1	CHANGED LUGS	BJC	09/11/2006
2	PLACARD CHANGED, AFT END MODIFIED FOR CROSS TUBE CLEARANCE	BJC	28/06/2007
3	HINGE RIVETS CHANGED, HANDLE DETAILS CHANGED, PLACARD CHANGED	BJC	14/10/2011

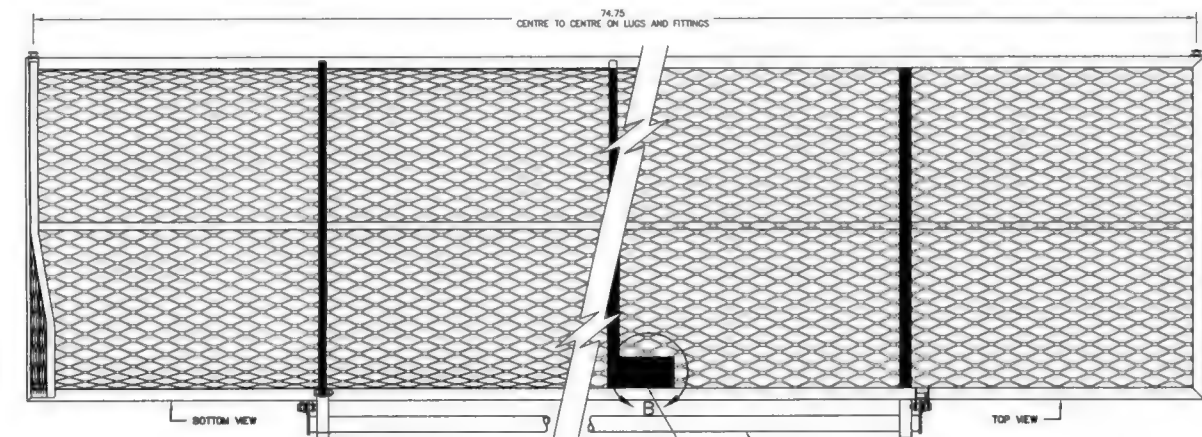


DETAIL A

SCALE 1 : 1  
LOOKING AT LOWER ATTACHMENT, UPPER ATTACHMENT SIMILAR  
TYPICAL FRONT AND REAR

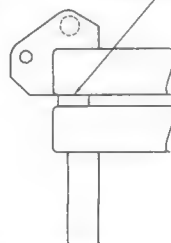
NOTE:

1. ALL DIMENSIONS SHOWN ARE FOR REFERENCE ONLY. DIMENSIONS OF COMPONENTS AND COMPLETE ASSEMBLY ARE DETERMINED IN PREVIOUS STEPS.

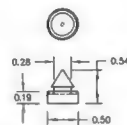


01 CARGO BASKET ASSEMBLY

DRILL 0.25 INTO LID  
ENSURE CLEARANCE FROM MESH  
3 PLACES MIN



BUMPER INSTALLATION  
SCALE 1 : 1



08 BUMPER  
SCALE 1 : 1



DETAIL B

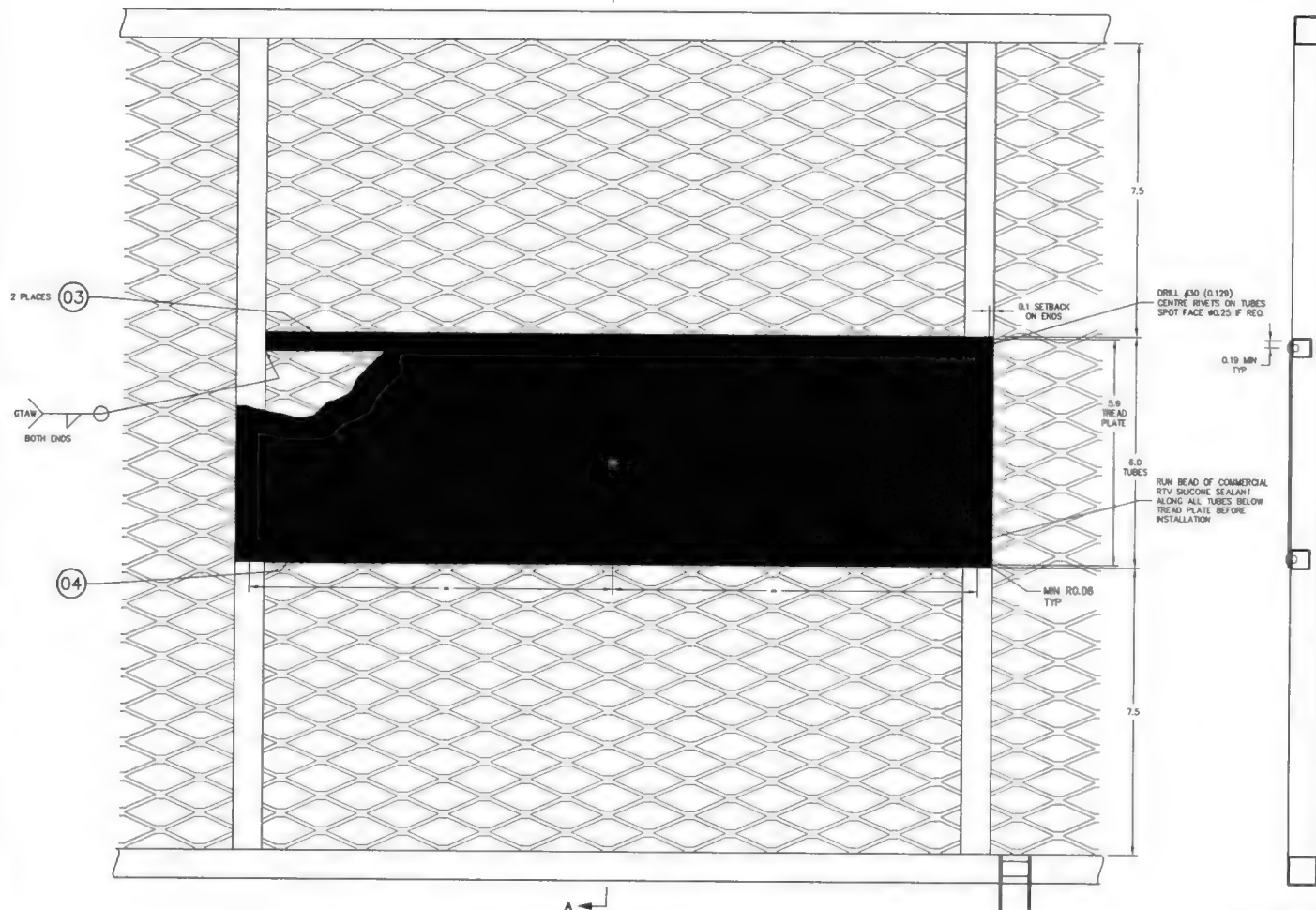
SCALE 1 : 1  
LOOKING AT PLACARD BRACKET

A/R	AN800-816	WASHER				
4	40088-14	FITTING	ANCRA			
4	CR3213-4-02	CHERRY RIVET				
8	CR3213-5-02	CHERRY RIVET				
A/R	CR3213-5-02	CHERRY RIVET				
3	48205-14	08 BUMPER	ARGUS INDUSTRIES			
1	69827-01	07 PLACARD				
1	64255-01	D6 HANDLE BAR INSTALLATION				
1	MS20001P4	D5 PIANO HINGE			8 FEET LONG	
1	36280-01	D4 BRACE ASSEMBLY				
1	69812-01	D3 LID ASSEMBLY				
1	69811-01	D2 BASKET BODY ASSEMBLY				
1	69810-01	D1 CARGO BASKET ASSEMBLY				
D1	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
QTY	LIST OF MATERIALS					

BASIC CODE REF. HAS 523	DASH NO. FOR DIAMETER H=H/D. HEAD NEAR SIDE F=H/D. HEAD FAR SIDE	APPROVALS DRAWN: JEFF CLARKE CHECKED: E. BURGOW	DATE 11 APR 2006	<b>AERO DESIGN LTD.</b> CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAR 8908 2013 - 39TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2E 6R7 TEL: (403) 260-8087 FAX: (403) 260-8089 aerodesign@calough.net		
C=COUNTERSUNK D=DIMPLE (DIT)=# OF SHEETS TO BE DIMPLED	DASH NO. FOR LENGTH	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ARE: DECIMALS ANGLES X.XXX ±0.010 ±1/2° X.XX ±0.03 X.X ±0.1		BELL 206L, 407 QUICK RELEASE CARGO BASKET CARGO BASKET ASSEMBLY SCALE 1 : 4 DWG. SIZE DWG. NO. REV. SHEET 1 OF 1 A1 69810 3		



A



(01) BASKET LID ASSEMBLY

SECTION A-A

THIS DRAWING CONTAINS INFORMATION AND DATA WHICH IS PROPRIETARY TO AERO DESIGN LTD. THIS DRAWING OR ANY PORTION THEREOF, MAY NOT BE REPRODUCED, COPIED, OR DUPLICATED IN ANY MANNER, NOR USED FOR MANUFACTURING PURPOSES WITHOUT THE WRITTEN CONSENT OF AERO DESIGN LTD. BY ACCEPTING THIS DRAWING FOR REFERENCE, THE RECIPIENT AGREES TO HOLD AERO DESIGN LTD. HARMLESS FROM THE USE, OR MISUSE, OF THIS DRAWING OR THE INFORMATION CONTAINED THEREIN.			
REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
1	ADD BELL MEDIUM AND EUROCOPTER AS330 BASKETS, CHANGE TUBES	BJC	MAR 19/08
2	ADD EUROCOPTER EC135, MCDONNELL DOUGLAS MD680, BELL 206B BASKETS	BJC	DEC 4/08
3	ADD NEW AS330 AND 206L/407 MODELS	BJC	DEC 4/08
4	TITLE BLOCK UPDATED, MODEL LIST REMOVED, ADD ALT. RIVET, ADD NOTE 7	BJC	29/05/2014

NOTES:

1. THIS DRAWING IS AN OPTIONAL CONFIGURATION ADDING A TREAD PLATE STEP TO THE LID. THIS CONFIGURATION MAY BE APPLIED TO ANY OR ALL BAYS OF THE LID. REMAINDER OF LID ASSEMBLY IS TO BE FABRICATED IN ACCORDANCE WITH THE APPLICABLE DRAWINGS.
2. TUBES (ITEM 03) MUST BE WELDED IN PLACE BEFORE MESH IS WELDED ON BOTTOM.
3. REMOVE ALL BURRS AND BREAK SHARP EDGES.
4. WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AMS 2885C. WELDING ROD SHALL CONFORM TO ER70S-2 OR EQUIVALENT.
5. WHEN ASSEMBLY IS COMPLETE, FILL ALL VENT HOLES WITH ROSETTE WELD.
6. THOROUGHLY CLEAN AND POWDER COAT BASKET SUB-ASSEMBLIES PRIOR TO ASSEMBLY. INSTALL TREAD PLATE AFTER POWDER COATING.
7. WIDTH AND POSITION OF LID STEP MAY BE ADJUSTED TO MATCH LID DOOR INSTALLED IN ACCORDANCE WITH DRAWING 70402 ON ADJOINING BAY OF THE LID.

A/R	CR3213-4-02	BLIND RIVET	ALTERNATE: HR3213-4-02
1	70405-04	04 TREAD PLATE	ALUMINUM COMMERCIAL 0.063 TREAD PLATE
2	70405-03	03 TUBE	4130 STEEL COND N MIL-T-6730 0.5 X 0.035 WALL TUBE
1	SEE NOTE 1	02 BASKET LID ASSEMBLY	
70405-01	01 BASKET LID ASSEMBLY - MODIFIED WITH STEP		
01	PART NO	ITEM	DESCRIPTION MATERIAL MATERIAL SPEC STOCK SIZE
QTY			LIST OF MATERIALS

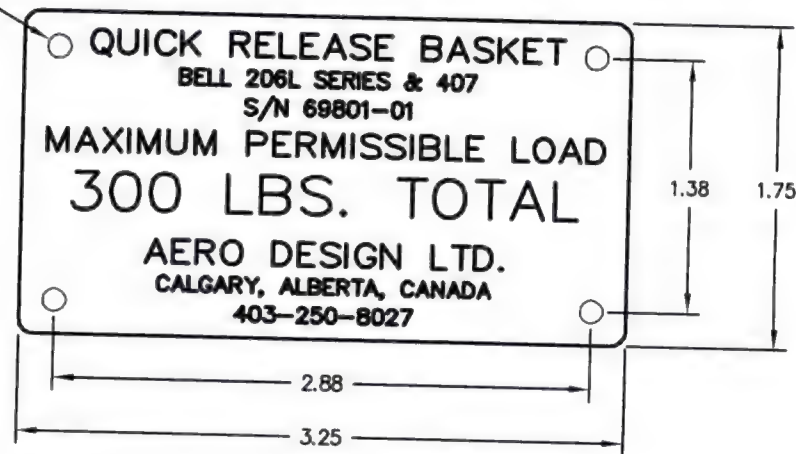
BASIC CODE REF. NAS 523 C=COUNTERSUNK D=DIMPLE DWIT=# OF SHEETS TO BE DIMPLED BASIC CODES: BJ=MS20470AD BB=MS20428AD ARN=CR3213 ARW=CR3212		DASH NO. FOR DIAMETER H=HFD. HEAD HEAR SIDE F=HFD. HEAD FAR SIDE DASH NO. FOR LENGTH + INSTALL NEW RIVET + REMOVE/REPLACE RIVET - EXISTING RIVET		APPROVALS DRAWN: JEFF CLARKE 21 SEPT 2008 CHECKED: E. BURGOIN UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 ±1/2" X.XX ±0.03 X.X ±0.1		DATE 21 SEPT 2008	
AERO DESIGN LTD. 2888A MALASPINA ROAD POWELL RIVER, BC, CANADA, V8A 0G3 TEL: 804.488.8870 www.aerodesign.co				CARGO BASKET LID STEP MODIFICATION			
SCALE 1 : 1.5 SHEET 1 OF 1		DWG. SIZE A1		DWG. NO. 70405		REV. 4	

NOTICE			
THIS DRAWING CONTAINS INFORMATION AND DATA WHICH IS PROPRIETARY TO AERO DESIGN LTD. THIS DRAWING, OR ANY PORTION THEREOF, MAY NOT BE REPRODUCED, COPIED, OR DUPLICATED IN ANY MANNER, NOR USED FOR MANUFACTURING WITHOUT THE WRITTEN CONSENT OF AERO DESIGN LTD. BY ACCEPTING THIS DRAWING FOR REFERENCE, THE RECIPIENT AGREES TO HOLD AERO DESIGN LTD. HARMLESS FROM THE USE, OR MISUSE, OF THIS DRAWING OR THE INFORMATION CONTAINED THEREON.			
REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
1	CHANGED TO ENGRAVED ALUMINUM	BJC	19 JUNE 2007
2	INCREASED LOAD	BJC	26 OCT 2011

#### NOTES

- ENGRAVE 0.007 DEEP AS FOLLOWS:  
 "QUICK RELEASE BASKET" - 0.125 HIGH  
 "BELL 206L SERIES & 407" - 0.080 HIGH  
 "S/N 69801-XX" - 0.080 HIGH  
 "MAXIMUM PERMISSIBLE LOAD" - 0.125 HIGH  
 "300 LBS. TOTAL" - 0.200 HIGH  
 "AERO DESIGN LTD." - 0.125 HIGH  
 "CALGARY, ALBERTA, CANADA" - 0.080 HIGH  
 "403-250-8027" - 0.080 HIGH

DRILL #30 (0.129)  
4 PLACES



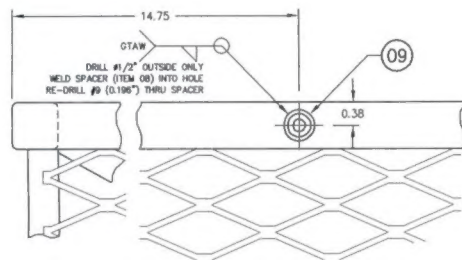
01 PLACARD

1	69827-01	01	PLACARD	6061-T6 ALUMINUM	QQ-A-250/11	0.063 SHEET
01	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
QTY	LIST OF MATERIALS					
			APPROVALS	DATE	<b>AERO DESIGN LTD.</b> CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAR 290M 2013 - 39TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2E 6R7 tel: (403) 250-8027 fax: (403) 250-8333 aerodesign@telusplanet.net	
			DRAWN: JEFF CLARKE	24 APR 2006		
			CHECKED: E. BURGOIN			
			UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 ±1/2° X.XX ±0.03 X.X ±0.1		BELL 206L SERIES AND 407 QUICK RELEASE CARGO BASKET PLACARD	
			SCALE 1 : 1	DWG. SIZE	DWG. NO.	REV.
			SHEET 1 OF 1	A4	69827	2



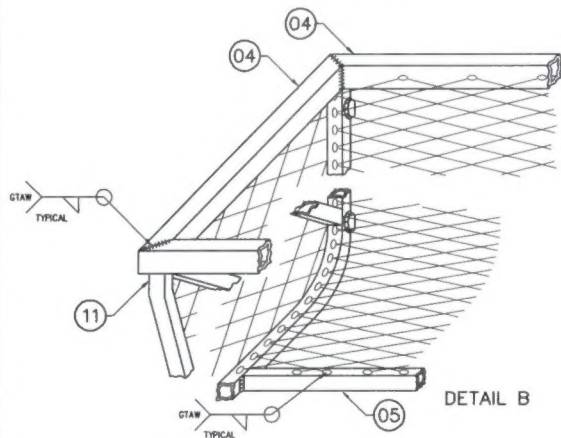
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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
1	LUGS CHANGED	BJC	09/11/2006
2	AFT END MODIFIED FOR CROSS TUBE CLEARANCE	BJC	29/06/2007
3	HANDLE BRACKET CHANGED, HOOP SPACING CHANGED	BJC	14/10/2011

- NOTES:
1. REMOVE ALL BURRS AND BREAK SHARP EDGES
  2. WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AMS 2685C. WELDING ROD SHALL CONFORM TO ER70S-2 OR EQUIVALENT.
  3. WHEN ASSEMBLY IS COMPLETE, FILL ALL VENT HOLES WITH ROSETTE WELD.
  4. THOROUGHLY CLEAN AND POWDER COAT BASKET SUB-ASSEMBLIES PRIOR TO ASSEMBLY.

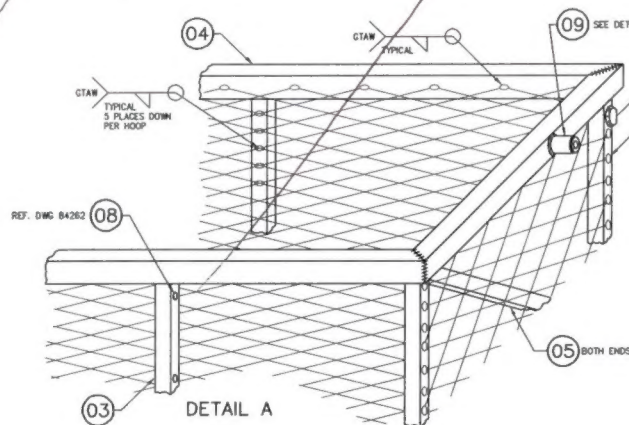


DETAIL C

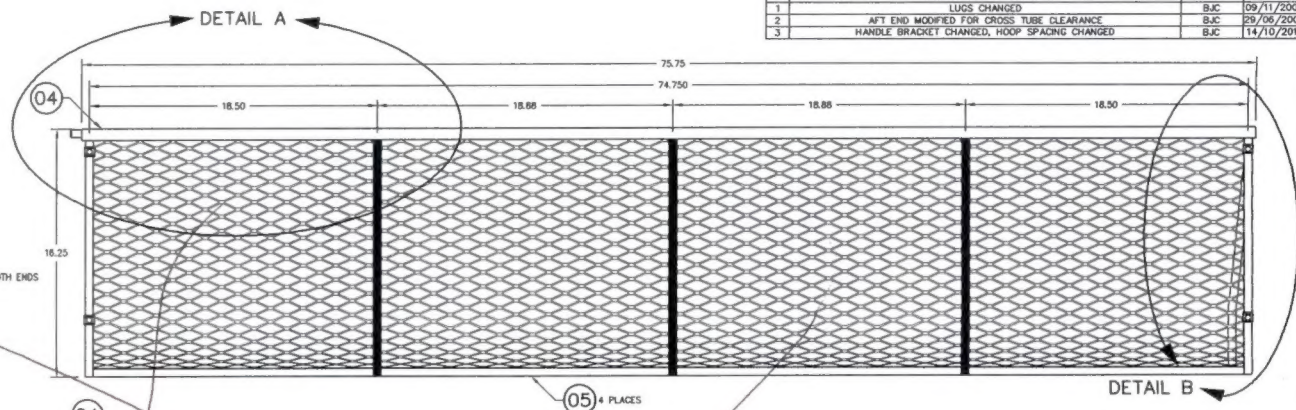
SCALE 1:1  
VIEW LOOKING AT FRONT RIM OF BASKET



DETAIL B



DETAIL A



DETAIL B

1	69822-01	11	AFT END HOOP	STEEL	COMMERCIAL	
A/R	3/4-16F	10	MESH			
1	49215-01	09	SPACER			
1	84262-01	08	HANDLE BRACKET ASSEMBLY			
		07				
		06				
A/R		05	TUBE	4130 STEEL COND. N	MIL-T-8736	0.5 X 0.035 SGR. TUBE
A/R		04	TUBE	4130 STEEL COND. N	MIL-T-8736	0.75 X 0.035 SGR. TUBE
3	49210-02	03	HOOP			
1	69821-01	02	FORWARD END HOOP			
1	69811-01	01	BASKET BODY ASSEMBLY			
D1	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
QTY	LIST OF MATERIALS					
APPROVALS				DATE		
DRAWN: JEFF CLARKE				11 APR 2008		
CHECKED: E. BURDON				<div><b>AERO DESIGN LTD.</b> CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAR 2007 8013 - 39TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2E 6R7 Tel: (403) 260-8087 Fax: (403) 260-8333 <a href="mailto:aerodesign@carleton.ca">aerodesign@carleton.ca</a></div>		
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 ±1/2" X.XX ±0.03 X.X ±0.1						
SCALE 1: 4				DWG. SIZE (DWG. NO.) REV.		
SHEET 1 OF 1				A1 69811 3		

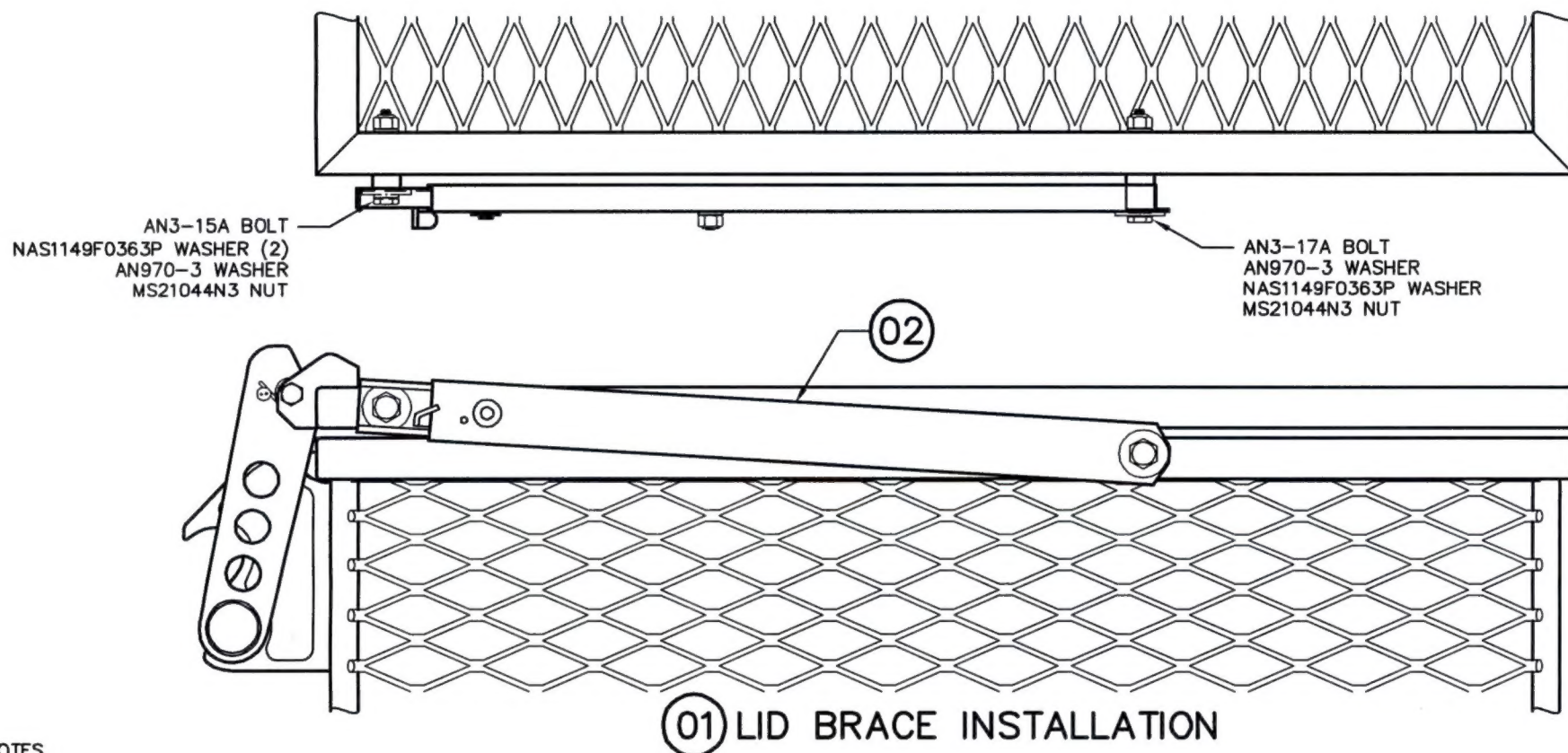
**AERO DESIGN LTD.**  
CONSULTING ENGINEERS, TRANSPORT CANADA APPROVED, DAR 2006  
2013 - 597H AVENUE N.E., CALGARY, ALBERTA, CANADA, T2E 6B7  
tel: (403) 265-8087 fax: (403) 265-8333 aerodesign@telusplanet.net

BELL 206L, 407  
QUICK RELEASE CARGO BASKET  
BASKET BODY ASSEMBLY




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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE	*	*



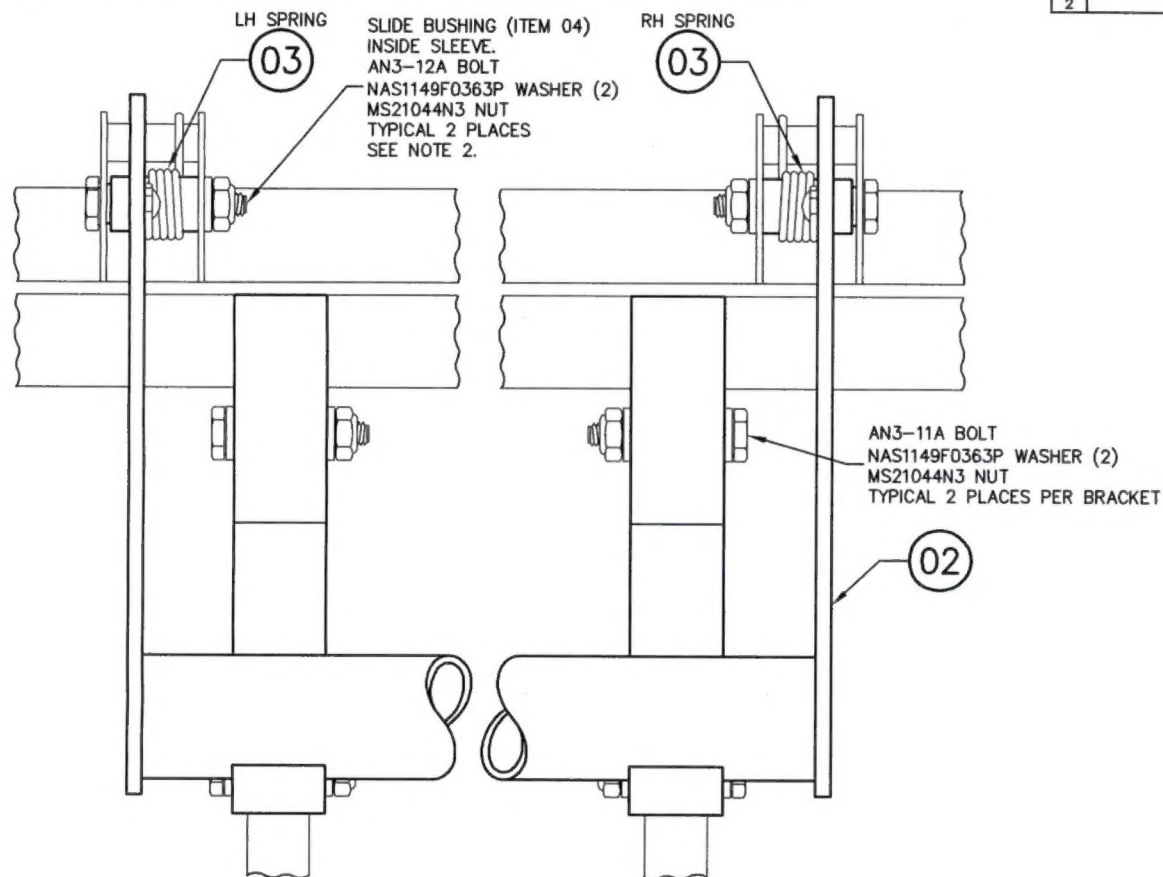
#### NOTES

- THIS DRAWING APPLIES TO ALL AERO DESIGN LTD. CARGO BASKET ASSEMBLIES.  
LID PROP IS TO BE INSTALLED ON THE FORWARD END OF THE BASKET AS INSTALLED ON THE HELICOPTER.

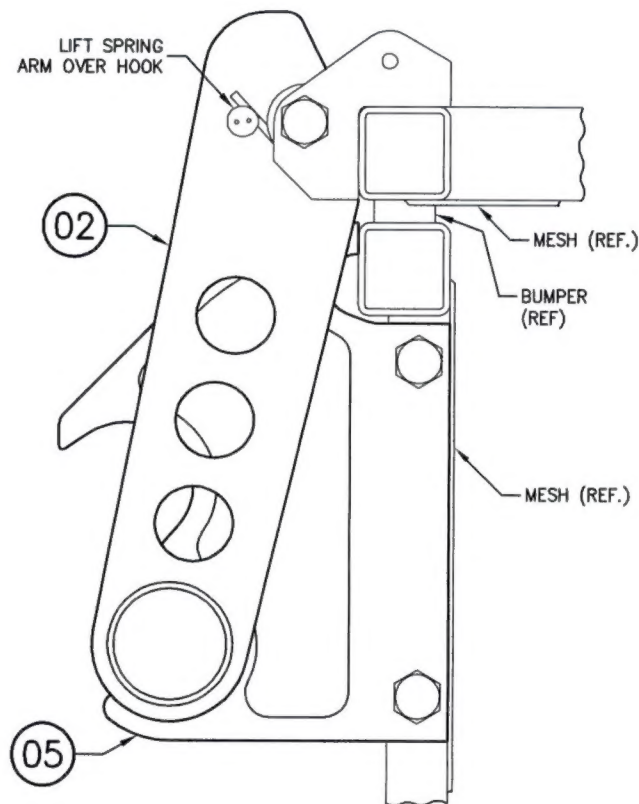
2	MS21044N3		NUT	APPROVALS	DATE		<div>AERO DESIGN LTD.</div> <div>9888A MALASPINA ROAD</div> <div>POWELL RIVER, BC, CANADA, V8A 0G3</div> <div>TEL: 804.483.2376      www.aerodesign.ca</div>			
3	NAS1149F0363P		WASHER	DRAWN: JEFF CLARKE	21 MAY 2014					
2	AN970-3		WASHER	CHECKED: JASON REKVE	21 MAY 2014					
1	AN3-17A		BOLT							
1	AN3-15A		BOLT	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS      ANGLES X.XXX ±0.010      ±1/2" X.XX ±0.03 X.X ±0.1		HELICOPTER CARGO BASKET ALL MODELS LID BRACE INSTALLATION				
1	36280-01	02	LID BRACE ASSEMBLY							
	84240-01	01	LID BRACE INSTALLATION							
01	PART NO.	ITEM	DESCRIPTION							
QTY.	LIST OF MATERIALS					NOT TO SCALE	DWG. SIZE	DWG. NO.	REV.	
						SHEET 1 OF 1	A4	84240	0	

NOTES:

1. THIS DRAWING IS AN ALTERNATE CONFIGURATION FOR THE HANDLE INSTALLATION SHOWN ON DRAWING 36255.
2. GREASE BUSHING (ITEM 04) USING MOBILGREASE 28 OR EQUIVALENT PRIOR TO INSTALLATION.



01 HANDLE INSTALLATION



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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE - CREATED FROM 36255	BJC	NOV 03/09
1	HANDLE END BRACKETS FLIPPED	BJC	SEPT 19/11
2	TITLE BLOCK UPDATED; ADD NOTE 2; HARDWARE UPDATED	BJC	MAR 13/14

A/R	MOBILGREASE 28		GREASE		MIL-PRF-81322F
4	AN3-11A		BOLT		
2	AN3-12A		BOLT		
10	NAS1149F0363P		WASHER		
6	MS21044N3		NUT		
2	84267-01	05	BRACKET		
2	36275-01	04	BUSHING		
2	36278-01	03	SPRING (1 LH, 1 RH)		
1	84261-01	02	HANDLE BAR ASSEMBLY		
	84255-01	01	HANDLE INSTALLATION		
01	PART NO.	ITEM	DESCRIPTION		MATERIAL
QTY.	LIST OF MATERIALS				

APPROVALS	DATE
DRAWN: JEFF CLARKE	03 NOV 2009
CHECKED: E. BURGAIN	

UNLESS OTHERWISE SPECIFIED  
DIMENSIONS ARE IN INCHES.  
TOLERANCES ON:  
DECIMALS ANGLES  
X.XXX ±0.010  
X.XX ±0.03  
X.X ±0.1



**AERO DESIGN LTD.**

9888A MALASPINA ROAD  
POWELL RIVER, BC, CANADA, V8A 0G3  
TEL: 804.483.2376 www.aerodesign.ca

**HELICOPTER CARGO BASKET  
HANDLE BAR INSTALLATION**

SCALE 1 : 1	DWG. SIZE	DWG. NO.	REV.
SHEET 1 OF 1	A3	84255	2





WO# \_\_\_\_\_

Approved Manufacturing Facility 73-04

Form 20.F.06

Rev. Original 27 May 2013